



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2432

Job Sheet 204308



28

DAS
21

Part No: D2432

Job Qty: 24 pcs

9-88

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/6/19

Job Tracking No:

Due Date: 1/6/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	24 pcs	1/6/20	1/6/20	0.17	6.19	Waterjet - Omax		<i>20/1/17</i>
130	HAAS 4 Axis - B4B	24 pcs	1/6/20	1/6/20	1.00	30.04	HAAS - 1 - B4B		<i>20/1/17</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	24 pcs	1/6/20	1/6/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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DAS
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9-89

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	20-1-17
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
150	QC 8	24 pcs	1/6/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
160	Packaging 3-1 - Stock - B4B	24 pcs	1/6/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B

DAS
ST260B 80 JAN 0 2020
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			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
170 QC 21 - SA	28 24 pcs	1/6/20	0.00 0.00	QC 21 - SA - 21 ✓
				QC 21 - SA - 70
				QC 21 - SA - 53
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2432 File Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Debur 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	88.8000 sf (3.7 ea)	120-Waterjet - Omax - 1	3154152 5228711 5235828
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Omax - 1	MUHMWB10	89	669	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD

Description: Bearpaw

Inspection Dwg: D2432

Rev: H

Work Order: 204308

Part Number: D2432

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	B17321484
B	0.200	+/-0.030	0.200	✓		D.G.	896009
C	0.25 x 45°	+/-0.030	0.25 x 45°	✓		Ver	"
D	R0.250	+/-0.030	R.0.250	✓		R.G.	Ref.
E	0.250	+/-0.010	0.255	✓		Ver	"
F	0.625	+/-0.030	0.635	✓		Ver	"
G	0.375	+0.030/-0.010	0.390	✓		Ver	"
H	0.950	+/-0.030	0.962	✓		Ver	"
I	19.000	+/-0.030	19.000	✓		Ver	"
J	Ø0.260	+0.005/-0.000	Ø.260	✓		TAPE	Ref.
K	Ø0.93	+/-0.030	Ø0.93	✓		G.P.	Ref.
L	0.30	+0.030/-0.000	0.310	✓		Ver	"
M	23.750	+/-0.030	23.750	✓		D.G.	896009
N	2.000	+/-0.030	2.000	✓		TAPE	Ref.
O	0.38	+/-0.030	0.38	✓		Ver	"
P						Ver	"
Q							
R							
S							
T							
U							
V							

Measured by: 52

Date: 23/07/15

Audited by: [Signature]

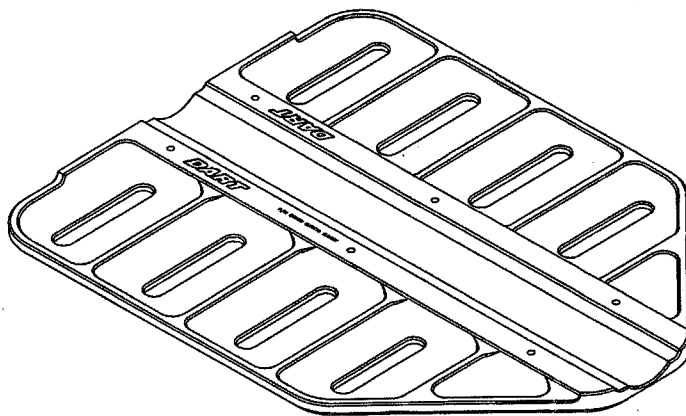
Date: 20/01/18

Preliminary Approval:

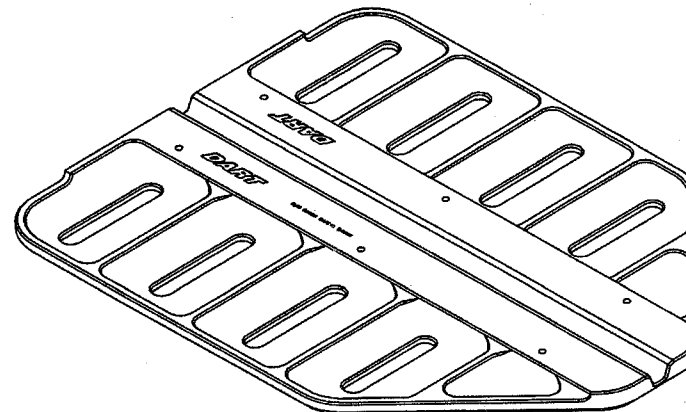
Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

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 WITHOUT NOTICE
 WORK ORDER
 NO. 204308



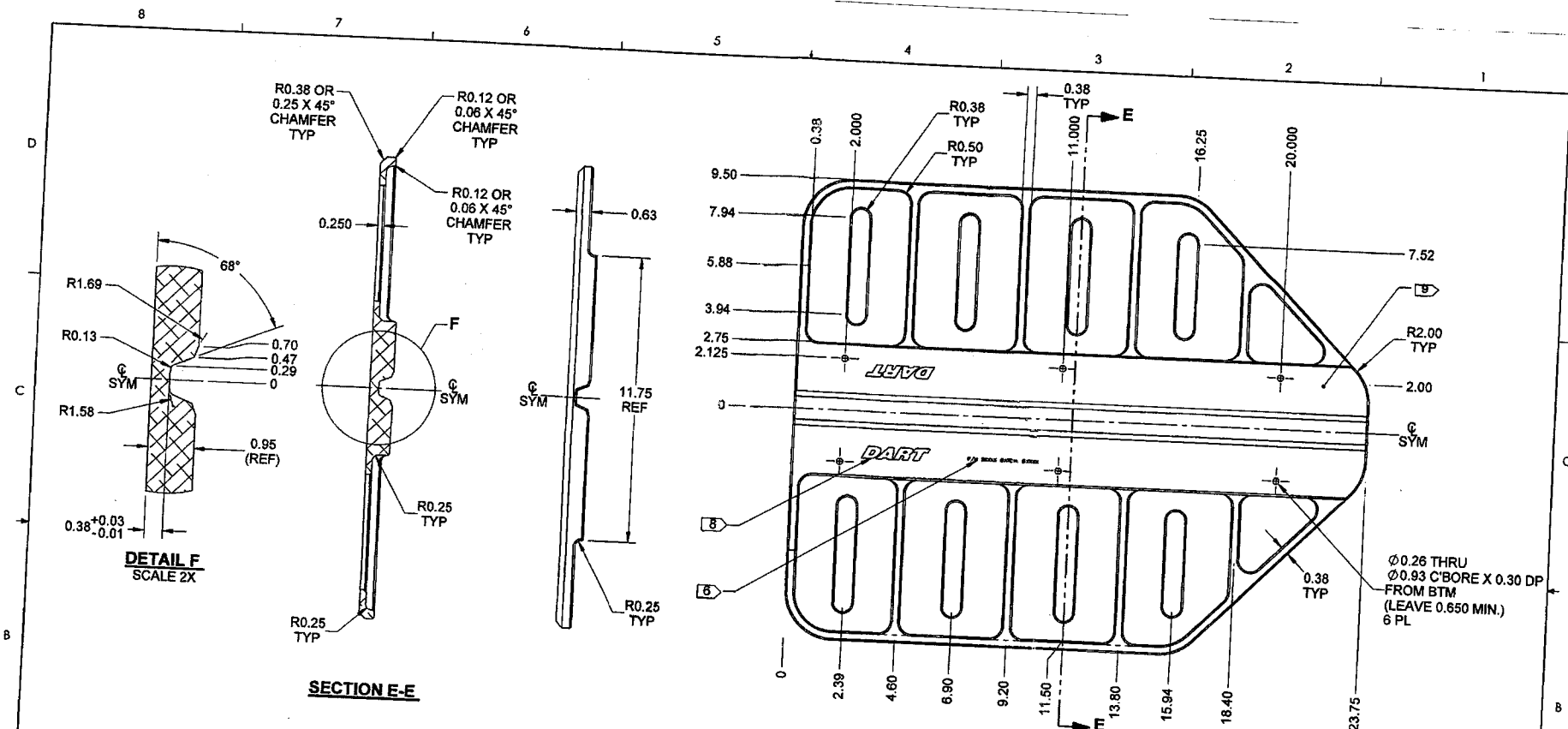
D2432F BEARPAW



D2432-3 BEARPAW

RELEASED
 2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	21	D2432	SHEET 1 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION E-E

D2432-3 BEARPAW

RELEASE
2012-10-16

- NOTES:**

1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950
(REF DART SPEC. MUHMWB10)

2) FINISH: NONE

4) UNITS: INCHES UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: ENGRAVE PART NUMBER

7) WEIGHT: 6.25 lbs

7) WEIGHT: 6.25 lbs

9) APPLY 0.06 x 45° CHAMFER TO MAX

10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

7/1/2012 11:27 AM DRAWING FILE "D2432-3-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2432 TITLE BEARPAW COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE EXEMPTED CUSTOMER THAT IT IS NOT TO BE REPRODUCED OR REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	REV.
DRAWN	AP		SHEET 3 OF
CHECKED	<i>ALS</i>		SCALE
MFG. APPR.	<i>at</i>		NT
APPROVED	<i>at</i>		
DE APPR.	<i>at</i>		
DATE 12.09.24			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY				
	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:					



Container No: S244819



Part: D2432

Job No: 204308

Serial No/Batch: S244819

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/06/20